

Ship 05/09

Dart Aerospace Ltd.

Date: Friday, 29/08/2008 8:36:08 AM  
User: Julie Lecocq

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 41660	Part Number	: D412630032
Estimate Number	: 10824	Drawing Number	: IIN D412-630
P.O. Number	:	Project Number	: N/A
This Issue	: 29/08/2008 S.O. No. :	Drawing Revision	: L
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 05/09/2008 Qty: 1 Um: Each
Previous Run	: 38769		
Written By	:		
Checked & Approved By	: <u>JLD 08.8.29</u>		
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC EST. REV. B 05.12.19 updated pick list EC EST. REV. C 07.11.12 ecn 1019, nochg EC verified by: DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*S. JLD 08.9.08*



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

*CHG001*

*JLD 08.9.08*

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630.p.17

\*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

*EJLD 08/09/08*

3.0	D3463042	Step Weldment Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	<i>B.416604</i>

*8/9/4*

*54*

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>37089</i>

*1/8 08/08/2008*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3443041

Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3443-041 Strut ass'y

Batch

41665

8/9/4

SP

(X)

6.0

D34439

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D3443-9 Pin

Batch

30228

SS 08/08/2008 (X)

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 AN4CH3 BOLT  
A/R MS20995c41e Lockwire

Batch

M63248  
M101537

SS 08/08/2008 (X)

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description  
1 AN4C14 BOLT

Batch

203248

SS 08/08/2008 (X)

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D3454-7 Bushing

Batch

38781

SS 08/08/2008 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M67139

JS 08/08/2008

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M66043

JS 08/08/2008

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	38782

JS 08/08/2008

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	B 44892

NO QTY

JS 07/09/05

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	M63286

JS 08/08/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	66763

83 28/09/05

①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\*

Test fit on aircraft in Eng. lab.

5 02/02/02

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	33730

AS 08/08/2008

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	35741

AS 08/08/2008

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	34842

AS 08/08/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch  
6 D3455-1 Spacer

35860

358782

AS 08/08/2008

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3455-3 Spacer

30227

AS 08/08/2008

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3462-042 Bracket ass'y

B35860

AS 08/08/2008

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN310-4 Nut

M167139

AS 08/08/2008

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 AN310-5 Nut

M167280

AS 08/08/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 AN3C5A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch  
3 AN3-C5A Bolt

M108744

JS 08/08/2008

27.0 AN44C12 eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN44-C12 Eyebolt

M107923

JS 08/08/2008

28.0 AN4C15 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN4C15 BOLT

M103248

JS 08/08/2008

29.0 AN5C11 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN5C11 BOLT

M103248

JS 08/08/2008

30.0 AN5C15 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN5C15 BOLT

M105160

JS 08/08/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C10	WASHER
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Comment: Qty.: 7.0000 EACH(s)/Unit Total : 7.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M108473

32.0	AN960C516	WASHER
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M162842

33.0	MS210433	Nut
------	----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	M108672

34.0	MS24665227	COTTER PIN
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	M166043

35.0	MS24665229	COTTER PIN
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	M19096

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 41660

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	10 8334

JS 08/08/29

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/08 (KRL)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev: B

8/9/8

see

(KJ)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09 J

Job Completion



mf 08-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

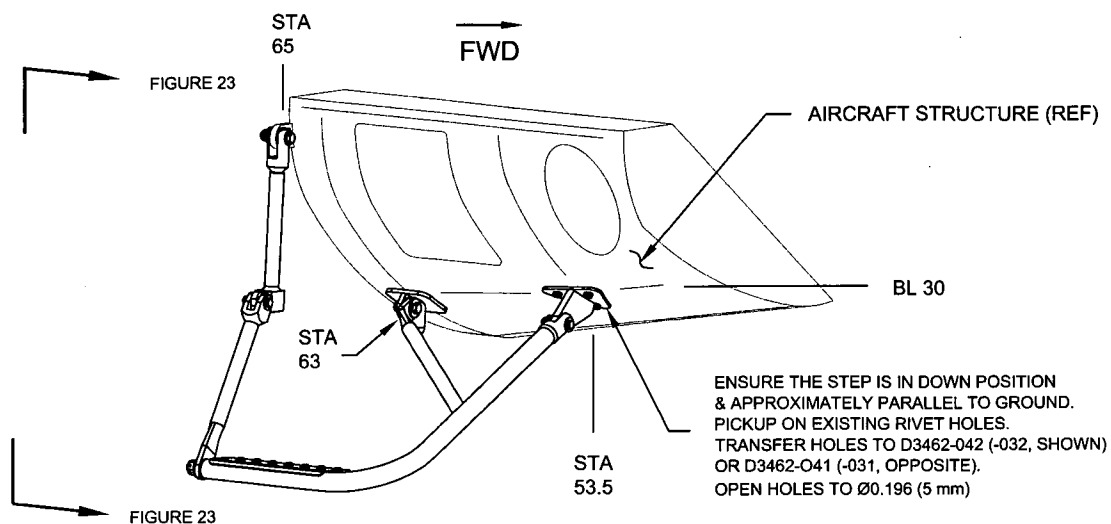
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

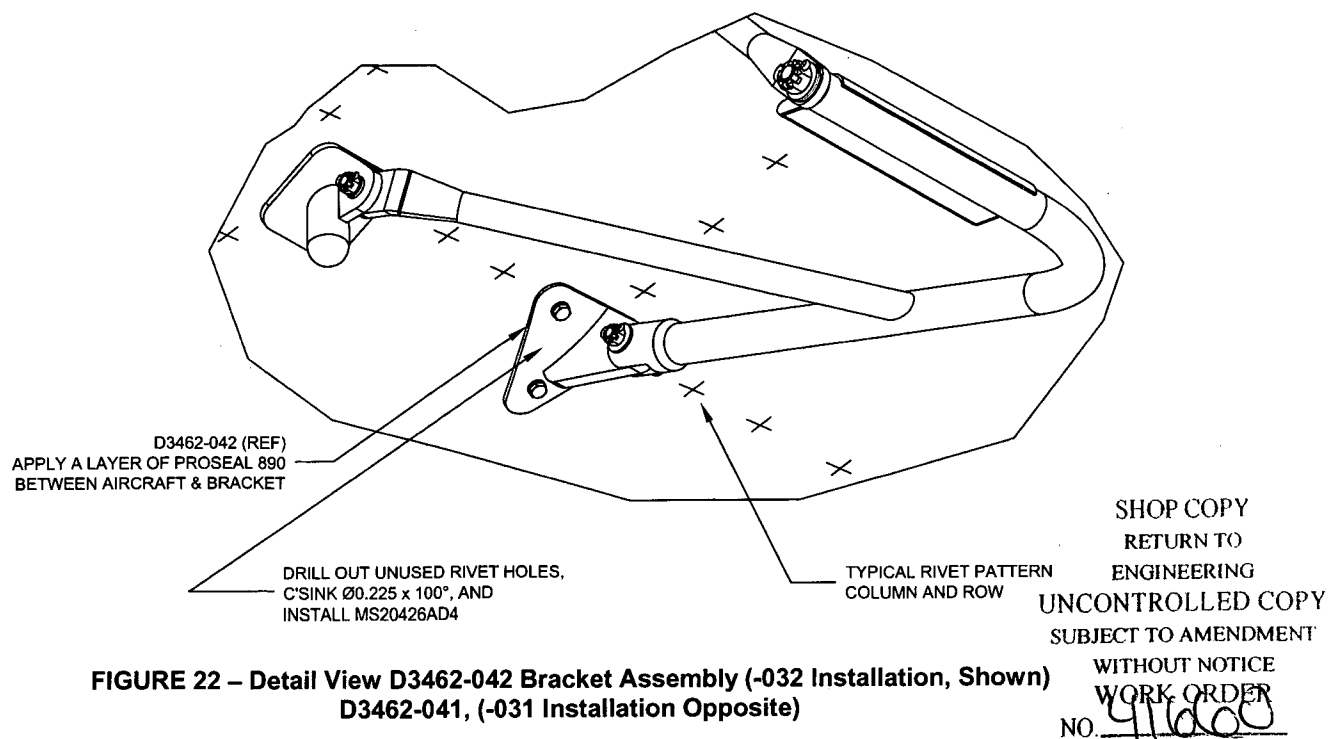
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation**

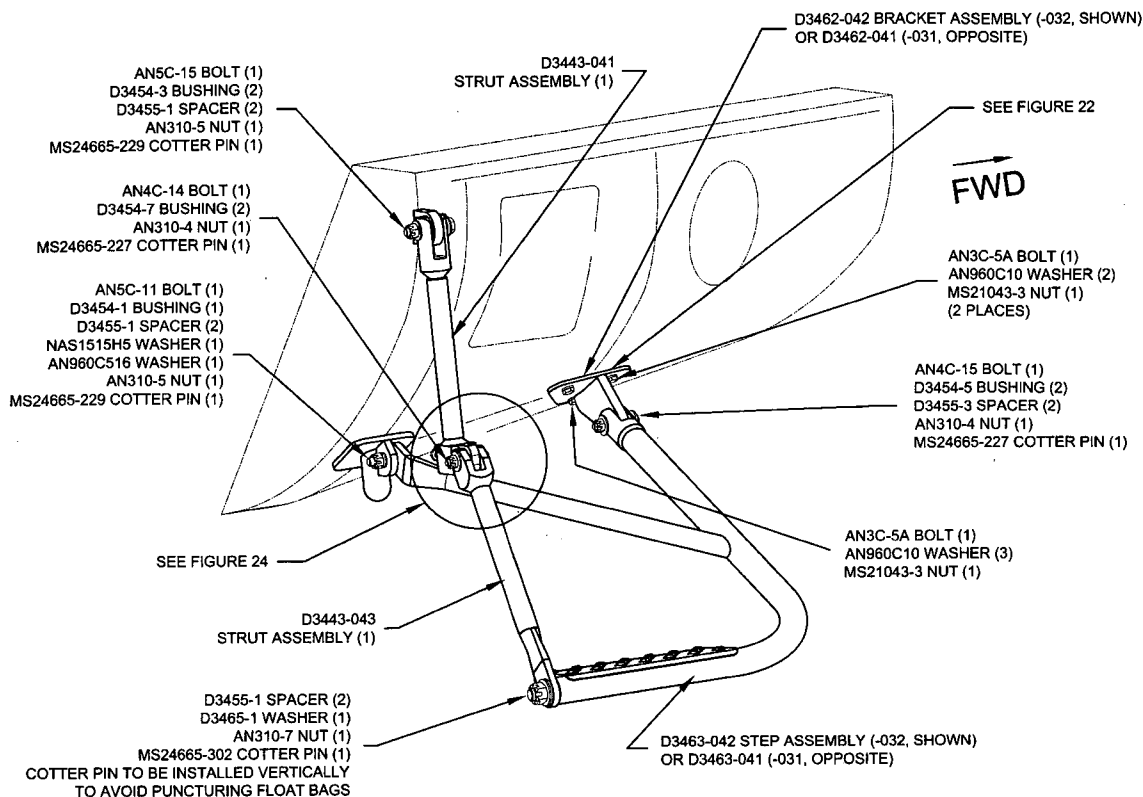
**FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)**



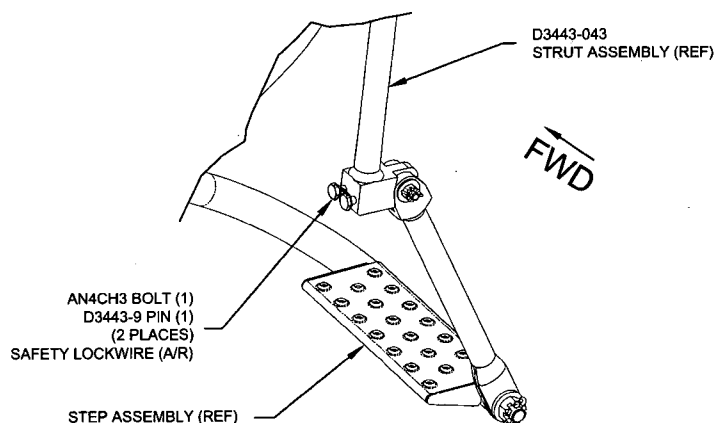
**FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)**

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Revision: **L**  
Date: 07.09.30



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**

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Revision: **L**  
Date: 07.09.30

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41660

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024™ HELI-ACCESS-STEP

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